

Work Order ID: 79327

79327

January-24-12 3:59:23 PM

Page 1

Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 24/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MC-51

Date: 12/01/24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	*Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3274	D

100- 0.00

100

DOCUMENT CONTROL

DC

Memo

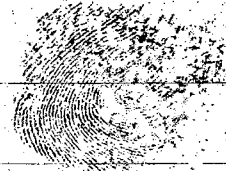
0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79327***79327***

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Item ID: D206-642-541

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 24/01/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg - *OK* 12/02/22
D3274, cut fwd end of tube with saw table setup D3274.2- remove fwd indexing ridge as per dwg D3274. Prepare for welding *BE 12-02-28*

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: *m/20/04* *BE 12/02/29*

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D32748 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe
batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

BE 12/02/29

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

114

QC5- Inspect part completeness to step on W/O

0.00

114

QC

Memo

0.00

Quality Control

8/12/12/29

116

QC10- Inspect visual per QSI004- ground welds

0.00

116

QC

Memo

0.00

Quality Control

8/12/12/29

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

1 3AD 12-02-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

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Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 24/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
150		0.00							
150									
Skidtubes									
Skidtubes	Memo	0.00							
	1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274								
	2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube								
	3-Bond web in place as per Dwg D3274 & QSI 015.								
	A/RSikaflex-291 <u>M119999</u>								
	Sikaflex expire date: <u>2012-12-13</u>								
	Start: <u>16:30</u> Time: <u>2012-2-29</u>								
	Finish: <u>17:00</u> Time: <u>2012-2-29</u> 12/03/12								
	(Adhere for 12 hours)								

DP 12-2-29

B 12/02/29

CF 12-2-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 24/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

DP 12-3-5

170

Skidtubes

0.00

170

Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

SAD 12-03-05
SAD 12-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D206-642-541

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 24/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC5- Inspect part completeness to step on W/O

0.00

4.5⁰
2.9¹¹

180

QC

Memo

0.00

Quality Control

1 0 8E 12/03/12

190

Skidtubes

0.00

190

Skidtubes

Memo

0.00

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/RAluminum Rod m120164

8E 12/03/12

3-Grind cross bolt welds flush as per Dwg D3274.

SAD 12-03-13

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

DP 12-3-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Item ID: D206-642-541

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 24/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

QC10- Inspect visual per QSI004- ground welds

0.00

210

QC

Memo

0.00

Quality Control

220

Pressure Wash per QSI005 4.3

0.00

220

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

1X QM-L 12/03/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 79327

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January-24-12 3:59:23 PM

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 24/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

230

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:05

OVEN TEMPERATURE: 375

FINISH TIME: 11:55

1 BL 12-3-19

240

QC3- Inspect Part Finish

0.00

240

QC

Memo

0.00

Quality Control

1 X/D M- 12/03/21

250

HandFinishing

0.00

250

HandFinish

Memo

0.00

Hand Finishing

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/RSikaflex-291

Sikaflex expire date:

M114596

M119999

12/08

1 X/D M- 12/03/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 79327***79327***

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January-24-12 3:59:23 PM

Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 24/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

QC5- Inspect part completeness to step on W/O

0.00

260

QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

1 BL 12321

270

HAND FINISHING RESOURCE #1

0.00

270

HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/RSikaflex-291

Sikaflex expire date:

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3

Batch:

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-291

Sikaflex expire date:

M119999

12/08

W/A

M119999

12/08

IXP M/L 12/03/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube
Start Date: 24/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 02/02/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 *280* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							1 BL 12-3-21
290 *290* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00		PRP 79323					12/3/08 SP
300 *300* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/3/29 MF 12-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 79327

79327

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
IPP Rev:F 08-06-02 add comment DD verified by:EC
IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-1-190

Manufactured

No

110

Each

135.0000

1

1

D2600-1-190

Extrusion Round 3" 206

**

DE 12/02/22

Location

Loc Qty

Loc Code

HALL

53

69622

53

LG

82

76912

82

D3285-1

Manufactured

No

110

Each

68.0000

1

1

D3285-1

Cap

**

DE 12/02/22

Location

Loc Qty

Loc Code

LG002

68

52511

21

52647

47

D3282-041

Manufactured

No

150

Each

17.0000

1

1

D3282-041

Float Web (206L/407)

**

1 CF 12-2-29

Location

Loc Qty

Loc Code

LG

17

74294

7

77498

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured

No

190

Each

559.0000

12

12

D2649

Cross Bolt Spacer

BE 12/03/12
*B 79565 *12*

Location

Loc Qty

Loc Code

LG

40

77574

40

LG001

519

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

400

D3275-1

Manufactured

No

190

Each

276.0000

12

12

D3275-1

Crossbolt Spacer

BE 12/03/12

Location

Loc Qty

Loc Code

LG002

276

66930

106

73393

118

74437

52

12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

250

Each

1,646.000

2

2

CR3212-4-03

Cherry Rivet

**

M-L 12/03/21

Location

Loc Qty

Loc Code

FP002

656

114859 ✓

656

ST331

990

110139

2

119017

988

2

D3415-041

Manufactured

No

250

Each

28.0000

1

1

D3415-041

Nut Plate

**

M-L 12/03/21

Location

Loc Qty

Loc Code

ST042

28

67605 ✓

28

1

CCR264SS3-3

Purchased

No

250

Each

881.0000

2

2

CCR264SS3-3

Cherry Rivet

**

M-L 12/03/21

Location

Loc Qty

Loc Code

ST331

881

113973 ✓

2

117849 ✓

135

119017

744

2

ALS4-1032-130

Purchased

No

250

Each

1,250.000

78

78

AI S4-1032-130

Insert

**

120181

78 M-L 12/03/21

Location

Loc Qty

Loc Code

ST280

1155

119084

1155

ST281

95

119632

95

*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

January-24-12 3:59:27 PM

Work Order ID: 79327

79327

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-15 Manufactured No

D3536-15

Gasket

270 Each 22.0000 1 1

80333

**

M-L 12/03/21

Location

Loc Qty

Loc Code

FP002

22

73318

22

D3536-23 Manufactured No

D3536-23

Gasket

270 Each 30.0000 1 1

**

M-L 12/03/21

Location

Loc Qty

Loc Code

FP002

30

43406

1

73312

17

74510

12

D3536-35 Manufactured No

D3536-35

Gasket

270 Each 29.0000 1 1

80335

**

M-L 12/03/21

Location

Loc Qty

Loc Code

FP002

29

73313

11

74511

18

D3536-39 Manufactured No

D3536-39

Gasket

270 Each 24.0000 1 1

**

M-L 12/03/21

Location

Loc Qty

Loc Code

FP002

24

73317

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-24-12 3:59:27 PM

Work Order ID: 79327

79327

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-15 Manufactured No

270 Each 20.0000 1 1

D3535-15

Wearshoe

**

m-l 12/03/21

Location	Loc Qty	Loc Code
FP001	20	
73315	8	
74512	12	

D3535-35 Manufactured No

270 Each 18.0000 1 1

D3535-35

Wearshoe

**

m-l 12/03/21

Location	Loc Qty	Loc Code
FP001	18	
67598	1	
70815	1	
73311	4	
74509	12	

D3535-39 Manufactured No

270 Each 30.0000 1 1

D3535-39

Wearshoe

**

m-l 12/03/21

Location	Loc Qty	Loc Code
FP001	30	
69759	1	
73316	17	
74513	12	

D3535-23 Manufactured No

270 Each 31.0000 1 1

D3535-23

Wearshoe

**

m-l 12/03/21

Location	Loc Qty	Loc Code
FP001	31	
73314	20	
74508	11	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

January-24-12 3:59:27 PM

Work Order ID: 79327

79327

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No

270

Each

9.0000

1

1

D3537-3

Wearpad

74500

**

1 m-k 12/03/21

Location

Loc Qty

Loc Code

FP002

9

76986

9

D3537-1 Manufactured No

270

Each

20.0000

9

9

D3537-1

Wearpad

79833

**

9 m-k 12/03/21

Location

Loc Qty

Loc Code

FP002

20

69817

5

77036

15

AN960C10L NAS1149C0332 Purchased No

270

Each

0.0000

80

80

***AN960C10I ***

washer

120648

**

80 m-k 12/03/21

AN960C416 NAS1149C0463 Purchased No

270

Each

0.0000

1

1

AN960C416

washer

117735

**

1 m-k 12/03/21

D3672-1 Manufactured No

270

Each

936.0000

2

2

D3672-1

Phenolic Washer

**

m-k 12/03/21

Location

Loc Qty

Loc Code

FP001

300

66821 ✓

300

ST060

636

72229

136

76277

500

2

✓

January-24-12 3:59:27 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

January-24-12 3:59:27 PM

Work Order ID: 79327

79327

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

2,799.000

80

80

AN3C4A

BOLT

120769

~~120648~~

**

80 M-12/03/21

Location

Loc Qty

Loc Code

ST350

2799

117313

2

117688

5

117872

10

118112

16

118451

2

118838

4

119749

760

120187

2000

AN4C5A

Purchased

No

270

Each

371.0000

1

1

AN4C5A

BOLT

**

M-12/03/21

Location

Loc Qty

Loc Code

FP002

18

112243 ✓

18

ST355

353

112243

253

119017

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

January-24-12 3:59:27 PM

Work Order ID: 79327

79327

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 02/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

94.0000

1

1

D2646

Aft Cap

79562

**

1 m/l 12/03/21

Location

Loc Qty

Loc Code

FP002

94

62678

5

68280

5

70945

1

71038

2

71070

2

73294

1

73825

78

D3413-1

Manufactured No

270

Each

93.0000

1

1

D3413-1

Ring

~~77940~~

**

1 m/l 12/03/21

Location

Loc Qty

Loc Code

ST420

4

66387

3

70773

1

ST464

89

75478

30

76754

59

80224

January-24-12 3:59:27 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**

07.02.12

DEO ATTACHED

COPY

RETURN TO

DRAWING

CONTROLLED COPY

FOR AMENDMENT

NOTICE

ORDER

79327

HLS

12/01/24

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

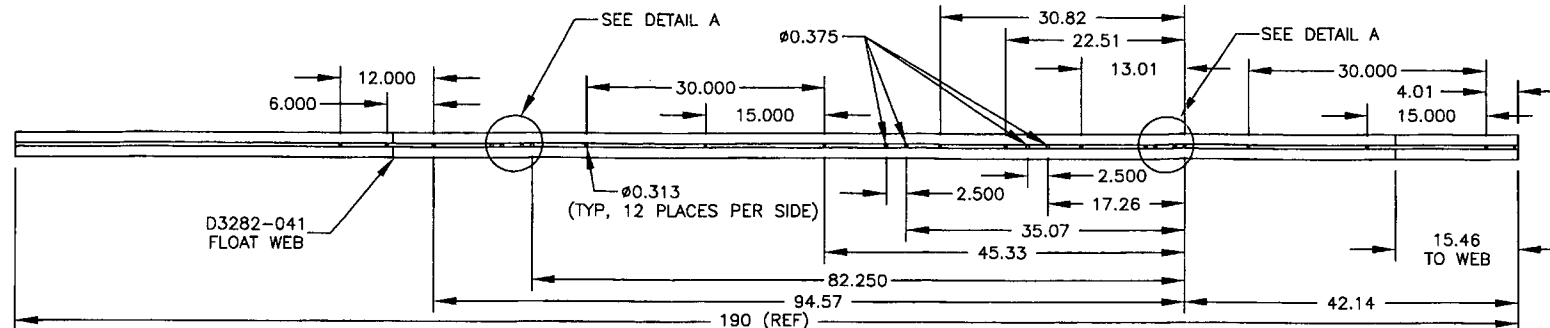
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

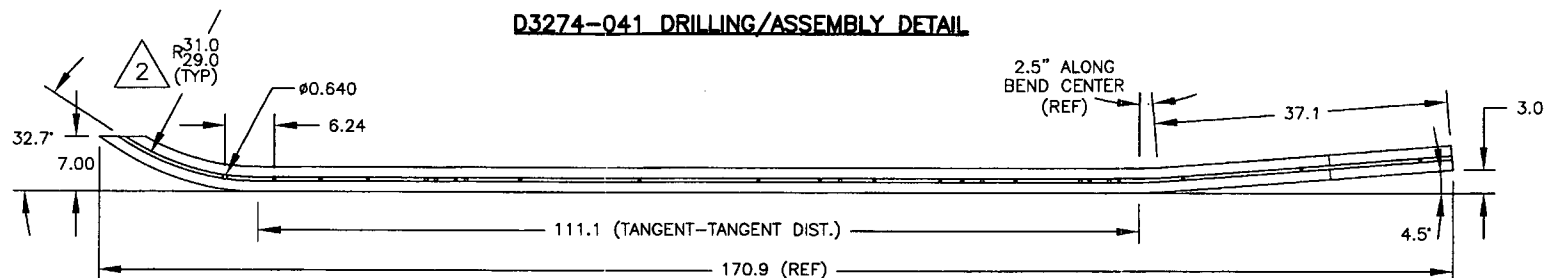
NOTE: Date & initial all entries

79327

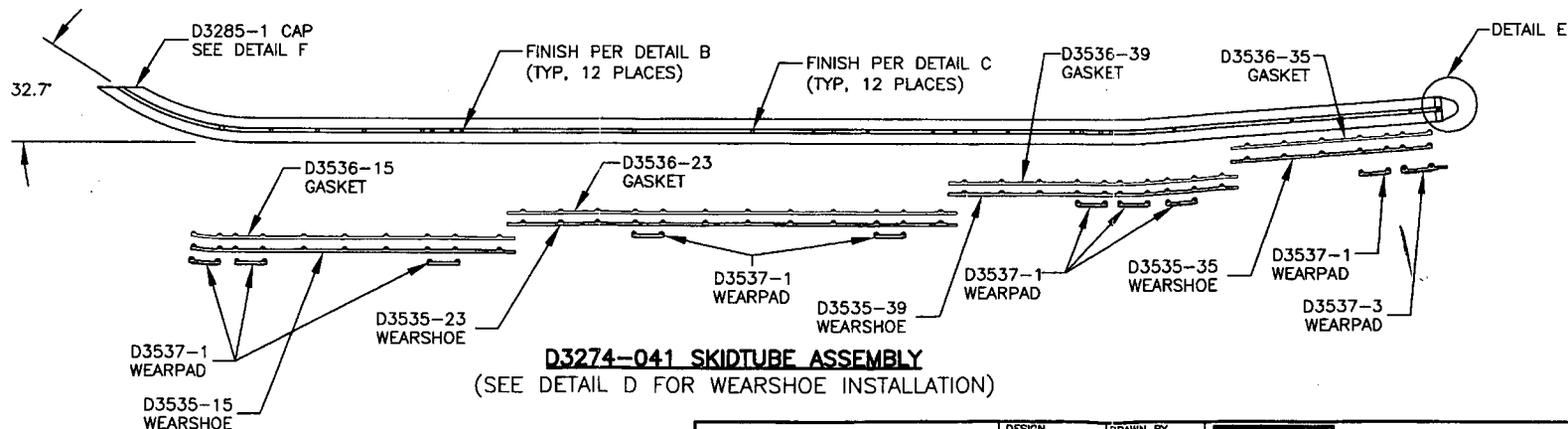
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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		DATE	06.12.19	TITLE		SKIDTUBE ASSEMBLY	SCALE 1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

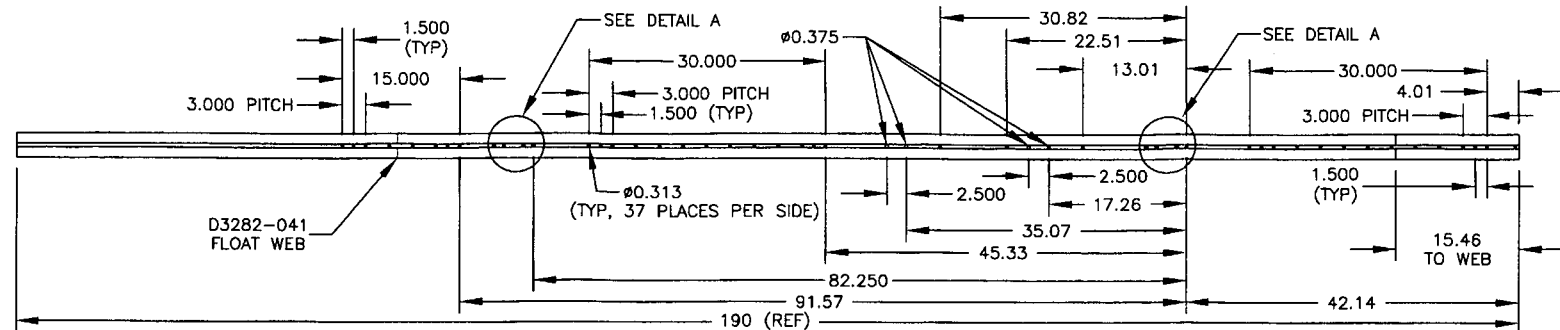
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

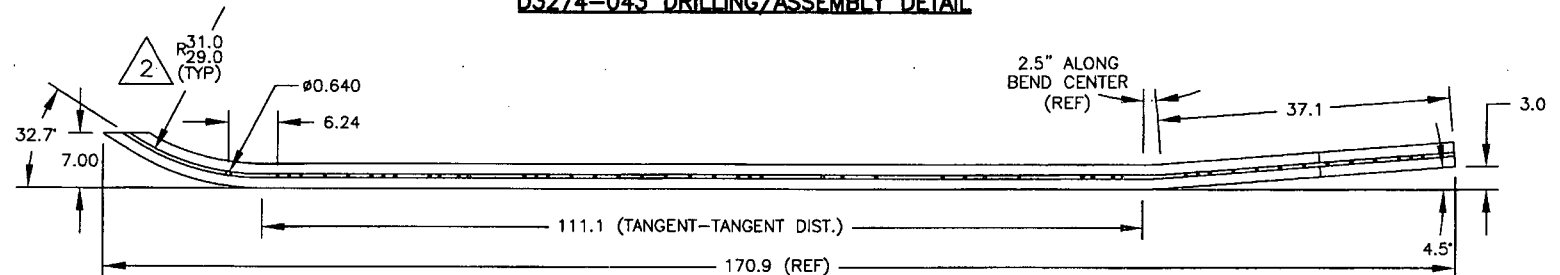
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

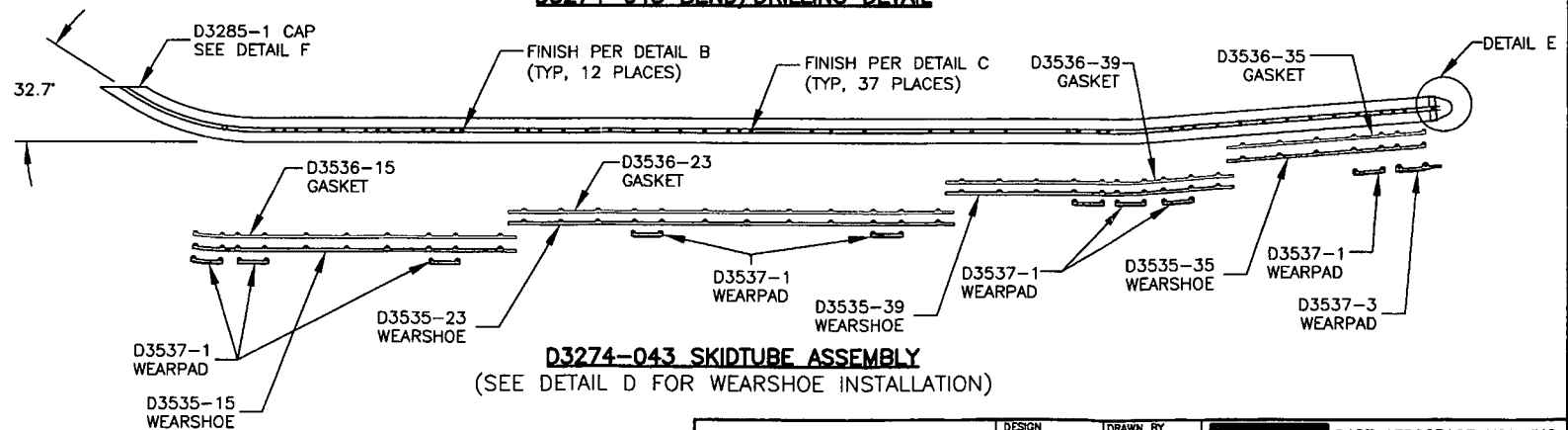
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DESIGN

CE

DRAWN BY

APPROVED

DART

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO.	
-------------	--

D3274

TITLE	SKIDTUBE ASSEMBLY
-------	-------------------

REV. D

SHEET 3 OF 4

SCALE

1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

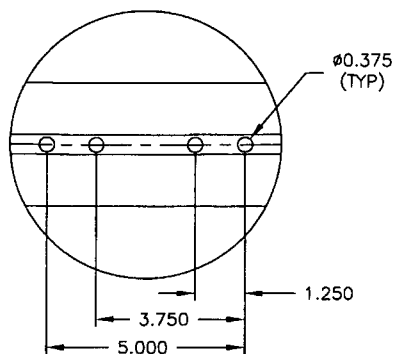
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

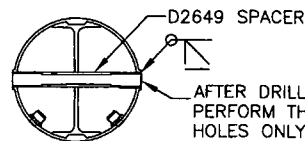
NOTE: Date & initial all entries

79327

DETAIL A: DRILL DETAIL

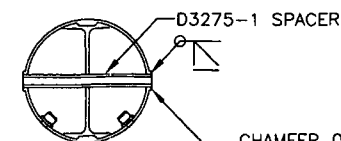


DETAIL B FOR 0.375 HOLES ONLY



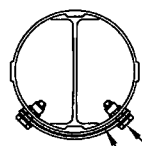
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

DETAIL D

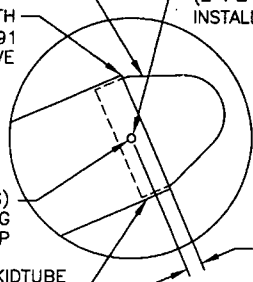


- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E

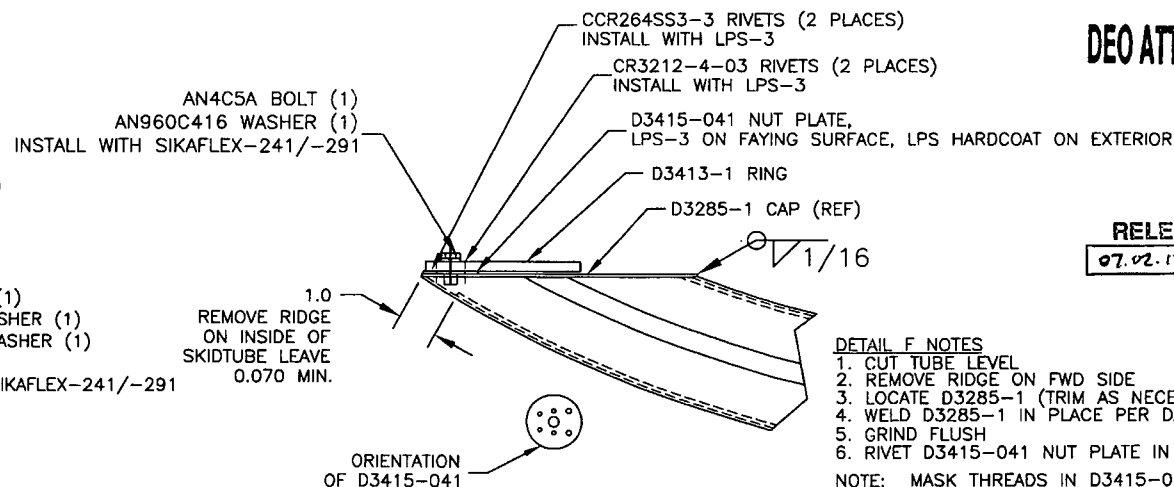
- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291
- D2646 CAP
SEAL WITH
SIKAFLEX-241/291
ADHESIVE



0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED

07.02.12

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 4 OF 4 SCALE 1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

79327

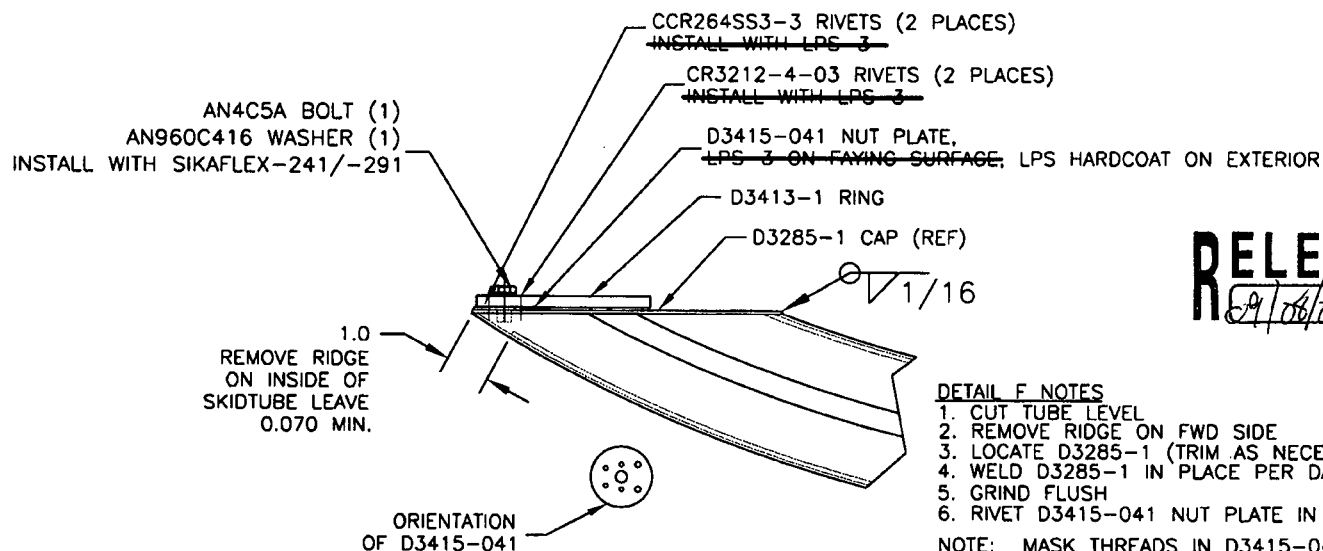
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 285

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 79322
Part number: A206-642-541
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier: David Hunt Date of Test Coupon 12.03.14
Welder: Barclay Elliott Date of Test Coupon 12.03.14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld